

Work Order ID 61536

Monday, August 30, 2010 10:20:29 AM



Butel # Proj

Page 1

Item ID: D2435

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206

Start Date: 8/30/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *10-8-30*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B10-9-2

8

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

G.A 10/10/05

8

0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

G.A 10/10/05

8

0

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SA 10/10/06

8 8

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP 61541

10/10/12 7 8

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/12 MF 10-10-12

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Picklist Print

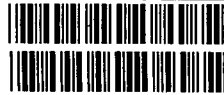
Monday, August 30, 2010 10:20:33 AM

Page 1

Work Order ID: 61536

Parent Item: D2435

Parent Item Name: Bearpaw, 206





Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	368.5473	3.2	25.6			
UHMW 1" Black												810-9-2	

Location

Loc Qty

Loc Code

MAT

368.5473

113903

79.7473

114624

8.8

115325

280

115328

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	61536
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060x45°	✓		Vern	GA-01
B	5.500	+/-0.030	5.507	✓		"	"
C	0.200	+/-0.030	0.197	✓		"	"
D	R0.250	+/-0.030	R0.250	✓		Rad Gage	ref.
E	0.250	+/-0.010	0.249	✓		Vern	GA-01
F	0.625	+/-0.030	0.630	✓		"	"
G	0.25 x 45°	+/-0.030	0.260x45°	✓		"	"
H	0.375	+/-0.010	0.377	✓		"	"
I	19.000	+/-0.030	19.000	✓		TAPE	GA-12
J	0.950	+0.030/-0.010	0.958	✓		VERN	GA-01
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		"	"
L	Ø0.930	+/-0.030	Ø0.925	✓		"	"
M	0.30	+0.030/-0.000	0.307	✓		Depth Gage	GA-08
N	0.375	+/-0.030	0.382	✓		Vern	GA-01
O	7.375	+/-0.030	7.375	✓		Vern	CNC-02
P	4.250	+/-0.010	4.250	✓		Vern	GA-01
Q	2.000	+/-0.030	2.006	✓		"	"
R	9.000	+/-0.010	9.000	✓		Vern	CNC-02
S	15.750	+/-0.030	15.750	✓		TAPE	GA-12

Measured by:	G.A	Audited by:	SA	Prototype Approval:	N/A
Date:	10/10/05	Date:	10/10/06	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>DS</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143	

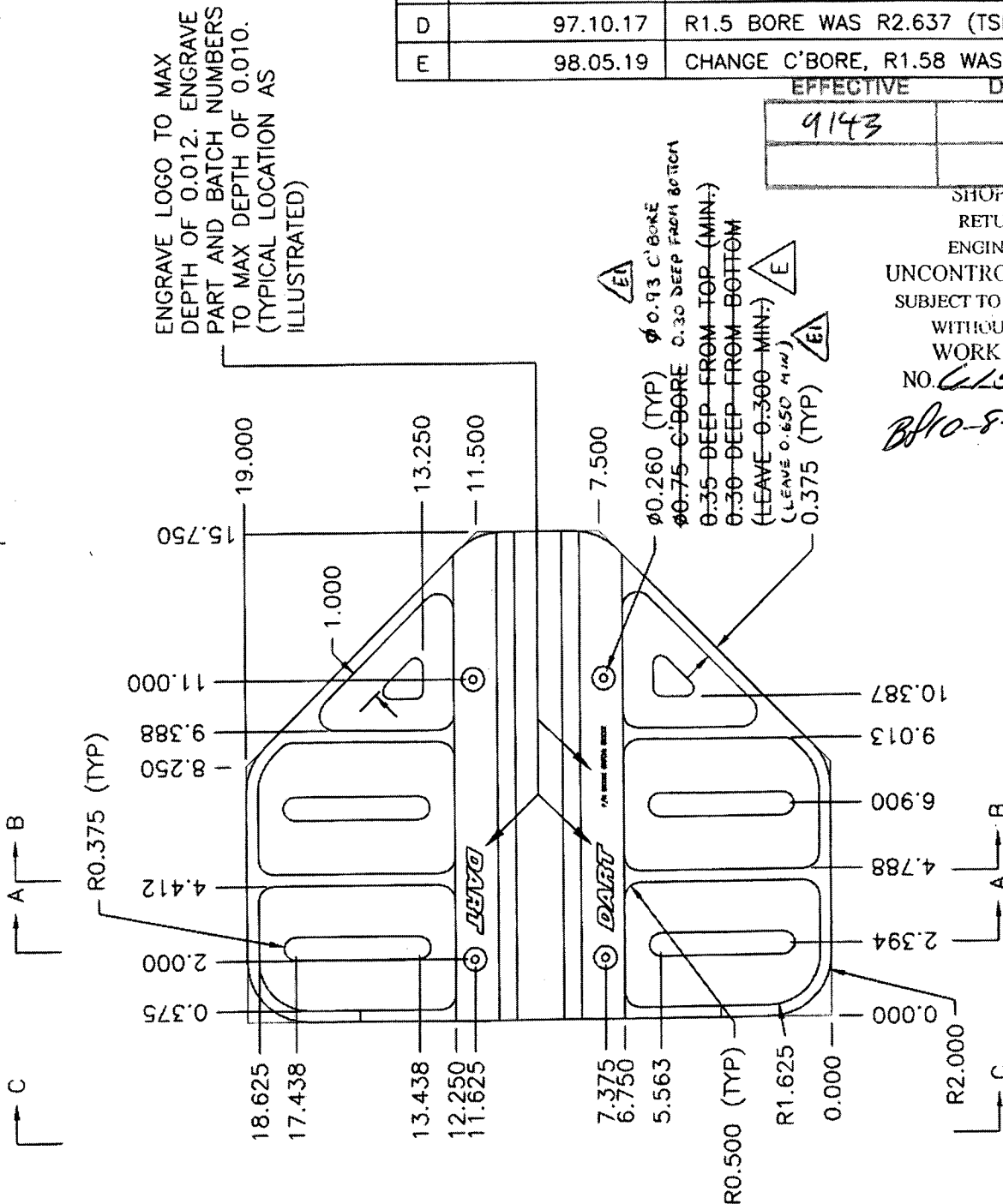
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 61539

B/A-8-30

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



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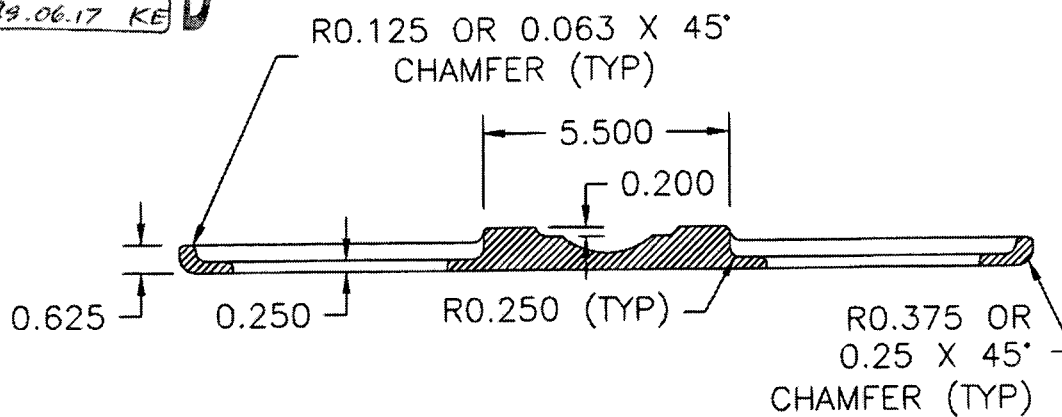
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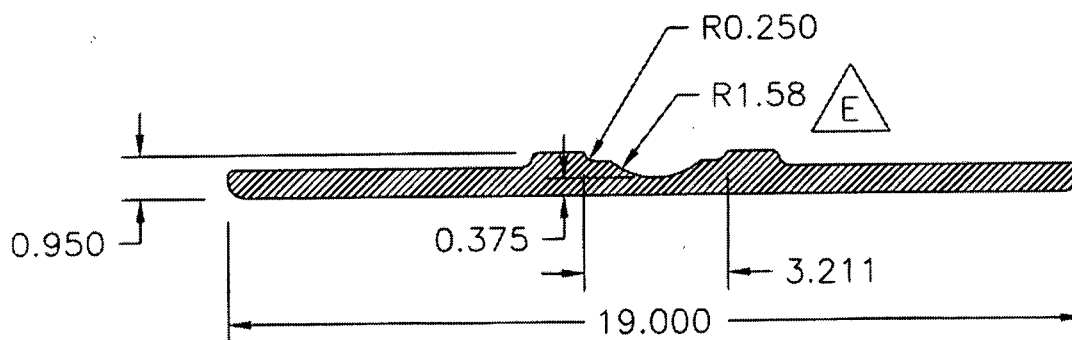
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

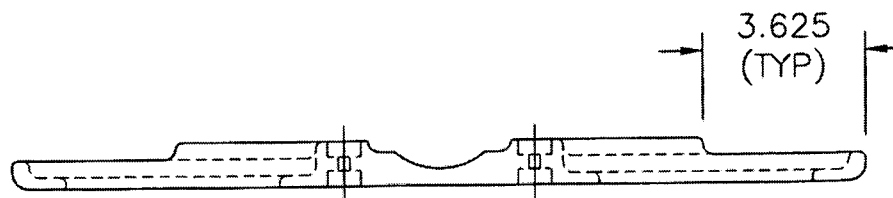


SECTION A-A

w/061530



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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